

WORK ORDER 2009-24

Date opened: 12 December 2008

Project: Quick Release Cargo Basket Assembly
Type: Bell 206B

Batch Quantity: 2 Complete Basket Assembly (81110-01)

Approval: SH09-5
Drawing List: DCL811-3

Fabrication and Assembly Drawing(s)	Description
81110, Rev. 0	Basket Ass'y
81111, Rev. 0	Basket Body Ass'y
81112, Rev. 0	Basket Lid Ass'y
36255, Rev. 1	Handle Installation
36261, Rev. 4	Handle Bar Ass'y
36262, Rev. 1	Handle Bracket Ass'y

Complete material tracking information on attached pages.

Work Order pre-completion Inspection:

Project is on Approval Limitation Record:	<u>Y ✓</u>
Document Control List revision level matches (or exceeds) STC:	<u>Y ✓</u>
Drawings revision levels match Document Control List:	<u>Y ✓</u>
Purchase order or Work order source is recorded for each part/ass'y:	<u>Y ✓</u>
Tests and inspections specifically called out on drawings are complete:	<u>Y ✓</u>
Release tags associated with all fabricated parts are attached:	<u>Y ✓</u>
All mounting hardware and supplies are included:	<u>Y ✓</u>

List all non-conformities raised: _____

Welder Signature: _____

Date: _____

Inspector Signature: _____

Date: _____

16 AUG 2011

Drawing: 81110 Revision 0
 Assembly: 81110-01 Cargo Basket Ass'y (Quick-Release, Short)

Qty Per	Part #	Description	Material	P.O.W.O.	Checked
2 Total	81110-01	Cargo Basket Assembly			
1	81111-01	Basket Body Assembly	Below		
1	81112-01	Basket Lid Assembly	Below		
1	36255-01	Handle Bar Installation	Below		
1	36280-01	Brace Assembly	9-2081 Brace		
1	MS20001P4	Piano Hinge		8104	
1	81127-01	Placard	0.063 Sheet, 6061-T6 Aluminum	5052	
3	49205-14	Bumper	Argus Industries Bumper	8071	
A/R	CR3213-4-02	Cherry Rivet		9078	
4	40088-14	Fitting	Ancra	8077	
4	AN960-616	Washer		7036	
1	AN3-15A	Bolt		7077	
1	AN3-17A	Bolt		9056	
4	AN960-10	Washer		9039	
2	AN970-3	Washer		8067	
2	MS21044N3	Nut		9056	

Processes	Per	Mat'ls Used	Inspection	Signature
Riveting	AC43.13-1B	HR3213-4-02 Rivets	JC	
Final Inspection	Drawing 81110		JC	

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: 81111 Revision 0
 Assembly: 81111-01 Basket Body Ass'y (Quick-Release, Short, 57.25" long)

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
1 Total	81111-01	Basket Body Assembly			
4	80322-01	Hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube	9057	
2	80324-01	Attachment Hoop	4130 Steel, 1.0 x 0.065 Sqr. Tube	8007	
A/R		Tube	4130 Steel, 3/4" x 0.035 Sqr. Tube	8064	
A/R		Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube	9057	
1	36262-01	Handle Bracket Assembly	Below		
1	49215-01	Spacer	1018 Steel, 1/2" Rod	7007	
A/R	3/4-16F	Mesh	Expanded carbon steel	8094	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		
Powder Coat	Drawing 81111			
Final Inspection	Drawing 81111			

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Drawing: 81112 Revision 0
Assembly: 81112-01 Basket Lid Ass'y (Quick-Release, Short, 57.25" long)

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
1 Total	81112-01	Basket Lid Assembly			
A/R		Tube	4130 Steel, 3/4" x 0.035 Sqr. Tube	8064	
1	49216-01	Spacer	1018 Steel, 1/2" Rod	7007	
1	36262-01	Upper Handle Bracket Assembly	Below		
1	36204-10	Placard Bracket	1018 Steel, 0.035" Sheet	9010	
A/R	3/4-16F	Mesh	Expanded carbon steel	8074	


Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		
Powder Coat	Drawing 81112			
Final Inspection	Drawing 81112			

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Drawing: 36255 Revision 1
Assembly: 36255-01 Handle Installation

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
1 Total	36255-01	Handle Installation			
1	36261-01	Handle Bar Assembly	Below		
2	36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire	9091	
2	36275-01	Bushing	SAE 660 Bronze, 5/16" Dia	7047	
2	AN3-14A	Bolt		8078	
4	AN960-10	Washer		9039	
2	MS21044N3	Nut		9056	


Processes	Per	Mat'ls Used	Inspection	Signature
Final Inspection	Drawing 36255			

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Drawing: 36261 Revision 4
Assembly: 36261-01 Handle Bar Assembly

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
1 Total	36261-01	Handle Bar Assembly			
1	36277-01	Handle Bar	316 Stainless, 1.0 x 0.035 Rnd. Tube	9078	
2	36271-01	Lever	304 Stainless, 0.105 Sheet	7006	
2	36274-01	Bushing	304 Stainless, 7/16" x 0.065 Rnd. Tube	8076	
2	MS20615-4M3	Rivet			


Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER308L		
Final Inspection	Drawing 36261			

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Drawing: 36262 Revision 1
Assembly: 36262-01 Handle Bracket Assembly

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
1 Total	36261-01	Handle Bracket Assembly			
1	36272-01	Basket Bracket	321 Stainless, 0.050 Sheet	2195	
2	36273-01	Lid Bracket	321 Stainless, 0.050 Sheet	2195	
2	36275-02	Support	304 Stainless, 5/16" Rod	2005	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER308L		
Final Inspection	Drawing 36262			

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AERO Design Ltd.
2013 - 39th Ave. NE
Calgary, AB, T2E 6R7

AUTHORIZED RELEASE CERTIFICATE

TRANSPORT CANADA
TCCA 24-0078
AMF # 73-04

Product: Quick Release Cargo Basket (Long) Part #: 81110-01

Approval #: SH09-5 Serial #: 81101-02


WO #: 2009-24 Quantity: 1

Eligibility: Bell 206B Work Status: Manufactured

Remarks: _____


I hereby certify that the product identified above has been manufactured in accordance with the applicable design data and the Canadian Aviation Regulations or applicable foreign regulations.

Dec 21/09
Date


Inspector's Signature

MBE
JETS



1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.	
4. Organization Name and Address AERO Design Ltd. – 2013 39 th Avenue NE, Calgary, Alberta, T2E 6R7					5. Work Order/Contract/Invoice WO 2009-24	
6. Item	7. Description Long Cargo Basket	8. Part Number 81110-01	9. Qty. 1	10. Serial/Batch No. 81101-03	11. Status/Work New	
12. Remarks						
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.			
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature		14c. Approved Organization Number
13d. Name Jeff Clarke		13e. Date (dd/mmm/yyyy) 16 Aug 2011		14d. Name		14e. Date (dd/mmm/yyyy)
Installer Responsibilities This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified. Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.						

VALLEY

KOOTENAI